

(19)

Europäisches Patentamt
European Patent Office
Office européen des brevets



(11)

EP 1 116 890 A1

(12)

EUROPEAN PATENT APPLICATION

(43) Date of publication:
18.07.2001 Bulletin 2001/29

(51) Int Cl.7: F16B 37/04

(21) Application number: 01300222.5

(22) Date of filing: 11.01.2001

(84) Designated Contracting States:
AT BE CH CY DE DK ES FI FR GB GR IE IT LI LU
MC NL PT SE TR
Designated Extension States:
AL LT LV MK RO SI

(71) Applicant: E & E Manufacturing Company, Inc.
Plymouth, MI 48170 (US)

(72) Inventor: Cutshall, Mark L.
Livonia, Michigan 48170 (US)

(30) Priority: 11.01.2000 US 175593 P
27.07.2000 US 626610

(74) Representative: W.P. Thompson & Co.
Coopers Building,
Church Street
Liverpool L1 3AB (GB)

(54) Caged fastener

(57) A cage-nut assembly (10) includes a nut (14) positioned within a cage structure (12). The cage structure (12) is configured to provide high torsional strength to prevent rotation of the nut (14). The cage structure (12) has a flat base (16) and an at least partially open end portion (30). The cage structure (12) includes a blocking member (26) preventing the nut (14) from moving laterally along the base (16) through the at least par-

tially open end portion (30). The blocking member (26) is relatively structurally weak in a direction orthogonal to a torsional rotation direction of the nut (14). The structurally weak blocking member (26) is bendable when less than approximately 20 lbs. of force (88.96N) is applied to the blocking member (26) to open the end portion (40) and allow the nut (14) to move laterally along the base (16) through the end portion for removal of the nut.

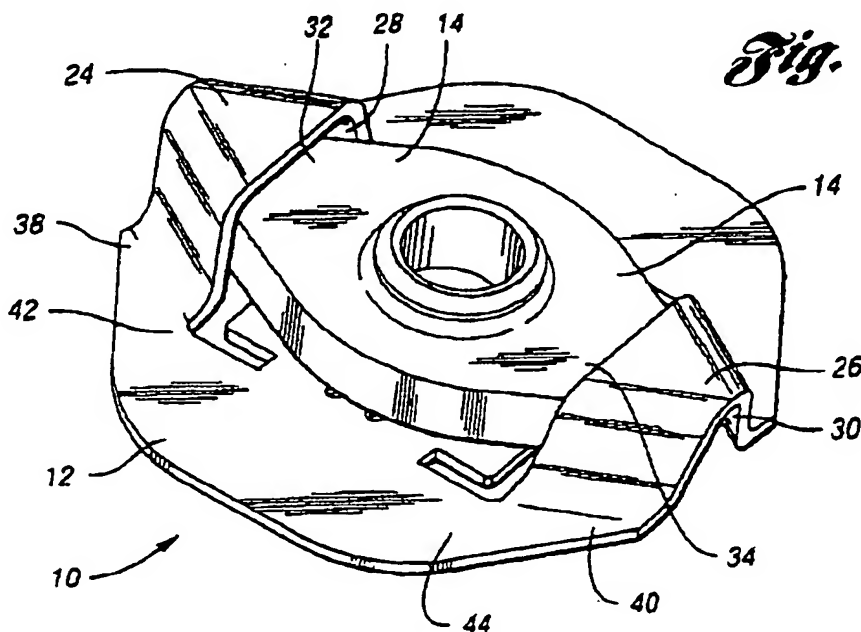


Fig. 8

BEST AVAILABLE COPY

EP 1 116 890 A1

Description

TECHNICAL FIELD

[0001] The present invention relates to caged female threaded fasteners which provide high torsional strength while allowing removal of the fasteners for servicing.

BACKGROUND ART

[0002] It is a common manufacturing practice to apply coatings of paint or other decorative or protective coatings to large subassemblies prior to final assembly of the completed product. For example, in the manufacture of automobiles, the body of the automobile will be formed and assembled, and then painted. Other automotive subassemblies, such as suspension parts, undercarriages, or closures for the automobile (such as the doors, hood, and trunk lid) are separately manufactured and painted, and are assembled with the painted automobile body to form a complete automobile.

[0003] In most cases, the subassemblies of the automobile will be secured to the auto body by threaded fasteners. However, the use of threaded fasteners often presents difficulties in final assembly. For example, in the case of assembling a door into a body, one of the matching threaded fasteners, for example, a female fastener, may be located inside a door pillar. The door pillar in a modern automobile of unibody construction very often is a hollow metal part which may be completely enclosed after manufacture of the vehicle body. In order to provide a female fastener inside the pillar, it is necessary to mount the female fastener, for example by welding, inside the pillar when the body is being manufactured.

[0004] Due to variations in manufacturing tolerances, a degree of position adjustment for the female fastener must be provided so that the door and body may be properly aligned during final assembly. Position adjustment is provided by using a female fastener called a "cage-nut", which is usually a nut encaged in a structure that is attached to the inside of the door pillar. The nut is provided with a range of movement within the encaging structure so that when the door is assembled to the body, the alignment of the door and the body can be adjusted until they meet manufacturing standards.

[0005] Cage-nuts are also frequently used in situations where the nut is not completely enclosed, such as on the frame of the vehicle. In these situations, the use of a cage-nut welded onto the body prior to final assembly reduces the time needed for final assembly of the automobile.

[0006] It has been found, however, that during the step of painting and baking paint on the body of the auto, that the nut will often weld or adhere to the cage. This paint-welding creates problems in the step of assembling and aligning the door or other subassembly within the body, because the nut no longer has any freedom

of movement. It can be difficult to free the paint welded nut from the cage if it is in an enclosed space. Consequently, the final assembly of the automobile will be slowed while these parts are freed up enough so that the door or other subassembly can be properly aligned and assembled with the body.

[0007] Another problem associated with such cage-nut assemblies is that a bolt may be stripped or cross-threaded into the encaged nut, particularly if the nut is misaligned as a result of adhering to the cage structure. In this situation, it is difficult, if not impossible, to remove the nut and bolt for servicing because the nut may not be removable from the cage. Accordingly, it is desirable to provide an improved cage-nut design in which the frequency of paint-welding the nut to the cage structure is minimized, and the nut is removable from the cage for servicing when the bolt or nut are stripped or cross-threaded.

DISCLOSURE OF INVENTION

[0008] The present invention overcomes the above referenced shortcomings of prior art cage-nut assemblies by providing a cage-nut assembly including a Teflon-coated nut and a cage structure which provides high torsional strength while providing a structurally weak portion which allows bending of the cage structure for removal of the nut for servicing.

[0009] In a first embodiment, a flat base is provided with opposing strap portions which wrap around opposing ends of an oblong (i.e., longer than wide, including diamond shape or other shape providing a portion for containment and torsional resistance), Teflon-coated nut. The flat base forms an enclosed aperture for receiving a bolt. The straps are bendable away from the body to facilitate nut removal. The straps are configured to provide high torsional strength. Small tabs extend from the base to space the nut away from the base to prevent paint-welding of the nut to the base, and are bendable to allow the nut member to seat when torqued down.

[0010] In another embodiment, standoff legs support a flat base with an enclosed aperture formed there-through for receiving a bolt. A rectangular Teflon-coated nut is positioned within the cage. The legs include small, bendable tabs which hold the nut in position and are bendable to allow the nut member to seat when torqued down (when a bending-force of approximately 65 lbs (289.12N) is applied to the legs). One of the tabs prevents the nut from sliding out of the cage, and is bendable to allow removal and servicing of the nut (when a bending-force of approximately 10 to 20 lbs. (44.48 to 88.96 N) is applied).

[0011] In a further embodiment, the cage-nut assembly includes a nut positioned within a cage structure, the cage structure being configured to provide high torsional strength to prevent rotation of the nut. Preferably, the cage structure provides sufficiently high torsional strength that the first failure would be that of the weld

holding the cage structure against a workpiece when a significant torque is applied to the nut (preferably at approximately 190 Nm). The cage structure has a flat base and an at least partially open end portion. The cage structure includes a relatively structurally weak blocking member preventing the nut from exiting the cage structure through the end portion. The structurally weak blocking member is bendable when less than approximately 20 lbs. of force is applied to the blocking member to open the end portion and allow the nut to move laterally along the base through the end portion for removal of the nut. The flat base includes a bolt-receiving aperture which is formed coextensively with the at least partially open end portion. The blocking member comprises first and second curved tangs formed coplanar with the flat base. The nut includes a protruding tubular portion which extends through the bolt-receiving aperture. Standoff legs support the flat base and include small projections to facilitate projection welding.

[0012] In the various embodiments, the flat base may be positioned flat against a workpiece to which the nut is being attached, or may be spaced from the workpiece by the above-described standoff legs.

[0013] Accordingly, an object of the invention is to provide an improved cage-nut assembly in which the nut is removable from the cage for servicing.

[0014] By way of example only, specific embodiments of the present invention will now be described, with reference to the accompanying drawings, in which:-

BRIEF DESCRIPTION OF DRAWINGS

[0015]

FIGURE 1 shows a perspective view of a cage structure in accordance with a first embodiment of the invention;

FIGURE 2 shows a plan view of the cage structure of Figure 1;

FIGURE 3 shows a side view of the cage structure of Figure 2;

FIGURE 4 shows a cross-sectional view taken at line A-A of Figure 2;

FIGURE 5 shows a plan view of a nut for use with the embodiment of Figure 1;

FIGURE 6 shows a side view of the nut of Figure 5;

FIGURE 7 shows a reverse side view of the nut of Figure 5;

FIGURE 8 shows a perspective view of a cage-nut assembly in accordance with the embodiment of Figure 1;

FIGURE 9 shows a perspective view of a cage-nut assembly in a slightly modified embodiment;

FIGURE 10 shows the cage-nut assembly of Figure 9 with the nut being removed from the cage structure;

FIGURE 11 shows an underside perspective view of a cage-nut assembly in accordance with an alternative embodiment of the invention;

FIGURE 12 shows a top perspective view of the cage-nut assembly of Figure 11;

FIGURE 13 shows a top plan view of the cage-nut assembly of Figure 11;

FIGURE 14 shows a side view of the cage-nut assembly of Figure 13;

FIGURE 15 shows a cross-sectional view taken at line A-A of Figure 13;

FIGURE 16 shows an enlarged view of detail B from Figure 14;

FIGURE 17 shows a plan view of the nut shown in Figure 11;

FIGURE 18 shows a side view of the nut of Figure 17;

FIGURE 19 shows a perspective view of a cage-nut assembly in accordance with a third embodiment of the invention;

FIGURE 20 shows a plan view of a nut corresponding with the embodiment of Figure 19;

FIGURE 21 shows a sectional view taken at line 21-21 of Figure 20;

FIGURE 22 shows a plan view of a slightly modified embodiment of a cage structure in accordance with the invention;

FIGURE 23 shows a side view of the cage structure of Figure 22; and

FIGURE 24 shows an end view of the cage structure of Figure 22.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0016] Referring to Figures 1-8, a first embodiment of a cage-nut assembly 10 is shown in accordance with the present invention. The cage-nut assembly 10 in-

cludes a cage structure 12, shown in Figures 1-4, and a Teflon-coated nut 14, shown in Figures 5-7, which cooperate to form the cage-nut assembly 10, shown in Figure 8.

[0017] The cage structure 12 includes a flat base 16 having a fully enclosed aperture 18 formed therethrough for receiving a bolt (not shown). Standoff tabs 20,22 are angled slightly upwardly with respect to the flat base 16 to hold the nut 14 away from the base 16 to prevent the nut from paint-welding to the base 16 (i.e. sticking to the base by dried paint). The tabs 20,22 are bendable to allow the nut to seat when torqued down.

[0018] The base 16 is preferably a stamped steel component, and includes integral straps 24,26, which form openings 28,30, respectively, for receiving opposing ends 32,34 of the oblong nut 14. The straps 24,26 are preferably stamped with the base 16 to form the openings 28,30.

[0019] As shown in Figures 5-6, the nut 14 is generally diamond-shaped and includes a central aperture 36 which is threaded to receive the bolt.

[0020] As viewed in Figure 8, the flat base 16 would be welded to a vehicle frame or other structural component, and the bolt would be inserted through an underside thereof, as viewed in this Figure. The openings 28,30 in the straps 24,26, respectively, are larger than the respective opposing ends 32,34 of the nut 14, thereby allowing the nut 14 to float for alignment with the bolt. The engagement of the opposing ends 32,34 of the nut 14 with the straps 24,26, respectively, provides very high torsional strength against rotation of the nut 14 during assembly.

[0021] The opposing ends 38,40 of the flat base 12 may be bent upward for servicing the nut 14. As the opposing ends 38,40 are pried upward, the flat base 12 would bend in the structurally weakest areas 42,44. In other words, the opposing ends 38,40 of the cage structure 12 are partially open, and the straps 24,26 are operative as blocking members which prevent the nut 14 from sliding through the partially open opposing ends 38,40. The blocking members are relatively structurally weak in a direction orthogonal to the torsional rotation direction of the nut, such that the blocking members may be pried up to allow the nut to slide through one of the opposing ends 38,40. The language "orthogonal to the torsional rotation direction of the nut" is intended to mean perpendicular to an arc swept out by a distal end of the rotating nut, and includes perpendicular directions which are in the plane of the arc or perpendicular to the plane of the arc.

[0022] Figures 9 and 10 show a slightly modified embodiment, wherein the opposing ends 38',40' are substantially enclosed. The ends 38',40' are only open at an underside thereof, as viewed in Figures 9 and 10. Figure 10 illustrates the end 40' having been pried upward with respect to the flat base 12 about the structurally weak portion 44 for removal of the nut 14 for servicing.

[0023] Referring to Figures 11-18, a further embodiment of the invention is shown. These figures show a cage-nut assembly 60, including the cage structure 62, which is preferably a stamped steel component, and a Teflon-coated rectangular nut 64.

[0024] The cage structure 62 includes standoff legs 66,68,70,72,74 which are welded to the vehicle body component by the conical projections 76,78,80, such as by projection welding (alternatively, the standoff legs could be spot welded to the vehicle component).

[0025] The standoff legs 66,68,70,72,74 support a flat base 82 which has an enclosed aperture 84 formed therethrough for receiving the bolt (not shown) which is inserted from the underside of the cage structure 62, as viewed in Figure 12, and protrudes through the lip 86 surrounding the threaded aperture 88 of the nut 64. The lip 86 also protrudes through the enclosed aperture 84 of the base 82, as shown in Figures 12 and 15.

[0026] This cage structure 62 in combination with the rectangular nut 64 provides substantial torsional strength for supporting the nut 64 against rotation when a bolt is driven into the nut 64 (preferably the weld fails before the cage structure at around 190 Nm). Between the legs 66,68,70,72,74, vertical retainer tabs 90,92,94,96 are provided for holding the nut 64 against the base 82.

[0027] The cage structure 62 is open at the longitudinal end between legs 66,68 such that movement of the bolt 64 therethrough is prevented only by the lateral retention tab 100. Accordingly, if a bolt is cross-threaded into the nut 64, the tabs 90,92,94,96 may be bent downward simply by pulling the nut 64 away from the base 82 by pulling on the bolt. This movement will bend the retainer tabs 90,92,94,96 out of the way for downward movement of the nut 64 so that the lip 86 does not interfere with the aperture 84 as the nut 64 is slid through the opening between the legs 66,68. In order to slide the nut 64 through the opening between the legs 66,68, the lateral retention tab 100 is pried upward to a position substantially parallel to the base 82. A bending force of about 10-20 lbs. (44.48 to 88.96N) is required to bend the retention tab 100. Accordingly, the nut 64 may be removed for servicing simply by bending the tabs 90, 92, 94, 96 to move the nut 64 away from the base 82, and then bending the lateral retention tab 100 upward to slide the nut 64 along the base out the end of the cage structure 62 between the legs 66, 68.

[0028] Figures 19-21 illustrate a third embodiment of the invention. In this embodiment, the cage-nut assembly 110 includes a cage structure 112 and a Teflon-coated nut 114, which cooperate to form the cage-nut assembly 110. The cage structure includes a flat base 116 which is supported by standoff legs 118,120,122,124. The flat base 116 and the standoff legs 118,120 cooperate to form an open end 126.

[0029] The standoff legs include bendable retainer tabs 128,130 which are configured to hold the nut 114 in position to be torqued down by a bolt. The tabs

128,130 are bendable to allow the nut 114 to move downward as viewed in Figure 19 when torqued down to a workpiece by such a bolt. The tabs 128,130 are bendable under approximately 65-80 lbs. (289.12 to 355.84N) of bending torque. Of course, the tabs 128, 130 could be configured in any variety of shapes, and the standoff legs could be combined to form a continuous support wall.

[0030] The flat base 116 includes a bolt-receiving aperture 132, which is formed coextensively with the open end 126 of the cage structure 112. The bolt-receiving aperture 132 receives a tubular extrusion 134 which extends from the nut 114. The aperture 135 of the tubular extrusion 134 receives a bolt, not shown, which torques down the nut 114.

[0031] First and second curved tangs 136,138 cooperate to form a blocking member which prevents the nut 114 from sliding along the flat base 116 through the open end 126 of the cage structure 112. The tangs 136,138 are bendable toward the angled sides 140,142, such as by a screwdriver, to allow the tubular extrusion 134 to pass by the blocking member formed by the curved tangs 136,138, thereby allowing removal of the nut.

[0032] This blocking member, like other embodiments of the invention, is configured to allow removal of the nut for servicing. Like other embodiments, the curved tangs 136, 138 are bendable when less than approximately 20 lbs. of force (88.94N) is applied to the curved tangs 136, 138, such as by a screwdriver, and the nut 114 may then be slid along the flat base 116 through the open end 126 of the cage structure 112.

[0033] The standoff legs 118,120 include small projections 144,146 to facilitate projection welding of the cage structure 112 to a workpiece to which the nut 114 is being attached.

[0034] Figures 22-24 show a slightly modified embodiment of a cage structure in accordance with the invention, wherein like reference numerals with a prime (') indicate like components from the embodiment of Figure 19. This embodiment differs from that of Figure 19 only in the number of bendable retainer tabs 128'. Of course, the number of retainer tabs and the number and configuration of the standoff legs could vary within the scope of the present invention.

[0035] While the best modes for carrying out the invention have been described in detail, those familiar with the art to which this invention relates will recognize various alternative designs and embodiments for practicing the invention without departing from the scope of the appended claims.

Claims

1. A cage-nut assembly comprising :

a nut;
a cage structure having the nut therein, said

cage structure configured to provide high torsional strength to prevent rotation of the nut; said cage structure having a flat base and an at least partially open end portion, said cage structure including a blocking member adjacent said at least partially open end portion preventing the nut from moving laterally along the base through said at least partially open end portion, said blocking member being relatively structurally weak in a direction orthogonal to a torsional rotation direction of the nut; wherein said structurally weak blocking member is bendable in said orthogonal direction when less than approximately 20 lbs. (88.96N) is applied to the blocking member to open said end portion and allow the nut to move laterally along the base through the end portion for removal of the nut.

2. The cage-nut assembly of claim 1, wherein the nut is Teflon-coated.
3. The cage-nut assembly of claim 1 or claim 2, wherein the nut is oblong and the flat base includes opposing straps extending therefrom to wrap around opposing ends of the oblong nut.
4. The cage-nut assembly of claim 3, wherein said blocking member is formed by one of the opposing straps, said one of the opposing straps providing high torsional strength and being bendable away from the flat base to enable removal of the oblong nut from the cage structure.
5. The cage-nut assembly of claim 4, further comprising small tabs extending away from the base to space the nut away from the base to prevent paint-welding of the nut to the base, said small tabs being bendable to allow the nut to seat when torqued down.
6. The cage-nut assembly of any of claims 3 to 5, wherein the oblong nut is generally diamond-shaped.
7. The cage-nut assembly of any of claims 1 to 6, wherein the flat base forms an aperture to receive a bolt.
8. The cage-nut assembly of claim 7, wherein said aperture is fully enclosed by the base.
9. The cage-nut assembly of any of claims 1 to 8, wherein the flat base is supported by standoff legs, and the legs include bendable retainer tabs configured to hold the nut in position, said bendable retainer tabs being bendable to allow movement of the nut away from the flat base in a perpendicular

direction with respect to the flat base.

10. The cage-nut assembly of claim 9, wherein the blocking member comprises a bendable lateral retention tab extending perpendicular to the flat base and blocking the at least partially open end which is formed between two of said standoff legs.

11. The cage-nut assembly of claim 9 or claim 10, wherein the flat base includes a bolt-receiving aperture which is formed co-extensively with the at least partially open end portion and the blocking member comprises first and second curved tangs formed coplanar with the flat base.

12. The cage-nut assembly of claim 11, wherein the nut includes a protruding tubular portion which extends through the bolt-receiving aperture.

13. The cage-nut assembly of any of claims 9 to 12, wherein said standoff legs include small projections to facilitate projection welding.

14. A cage-nut assembly comprising:

an oblong, Teflon-coated nut;
a cage structure having the nut therein, said cage structure configured to provide high torsional strength to prevent rotation of the nut;
said cage structure having a flat base and an at least partially open end portion, said cage structure including a relatively structurally weak blocking member preventing the nut from moving laterally along the base through said at least partially open end portion;
wherein said structurally weak blocking member is formed by one of first and second opposing straps which extend from the flat base to wrap around opposing ends of the oblong nut, said one of the first and second opposing straps providing high torsional strength and being bendable away from the flat base to enable removal of the oblong nut from the cage structure.

15. The cage-nut assembly of claim 14, wherein said first and second opposing straps wrap around opposing ends of the oblong nut.

16. The cage-nut assembly of claim 14 or claim 15, further comprising small tabs extending away from the base to space the nut away from the base to prevent paint-welding of the nut to the base, said small tabs being bendable to allow the nut to seat when torqued down.

17. The cage-nut assembly of any of claims 14 to 16, wherein the flat base forms an aperture to receive a bolt.

18. The cage-nut assembly of claim 17, wherein said aperture is fully enclosed by the base.

19. The cage-nut assembly of any of claims 14 to 18, wherein the oblong nut is generally diamond-shaped.

20. A cage-nut assembly comprising:

a nut;
a cage structure having the nut therein, said cage structure configured to provide high torsional strength to prevent rotation of the nut;
said cage structure having a flat base and an at least partially open end portion, said cage structure including a relatively structurally weak blocking member preventing the nut from moving laterally along the base through said at least partially open end portion;
wherein said structurally weak blocking member is bendable to open said end portion and allow the nut to move laterally along the base through the end portion for removal of the nut;
wherein the flat base is supported by standoff legs, and the legs include bendable retainer tabs configured to hold the nut in position, said bendable retainer tabs being bendable to allow movement of the nut away from the flat base in a perpendicular direction with respect to the flat base.

21. The cage-nut assembly of claim 20, wherein the blocking member comprises a bendable lateral retention tab extending perpendicular to the flat base and blocking the at least partially open end, which is formed between two of said standoff legs.

22. A cage-nut assembly comprising :

a nut;
a cage structure having the nut therein, said cage structure configured to provide high torsional strength to prevent rotation of the nut;
said cage structure having a flat base and an at least partially open end portion, said cage structure including a relatively structurally weak blocking member preventing the nut from moving laterally along the base through said at least partially open end portion;
wherein said structurally weak blocking member is bendable to open said end portion and allow the nut to move laterally along the base through the end portion for removal of the nut;
wherein the flat base includes a bolt-receiving aperture which is formed coextensively with the at least partially open end, and the blocking member comprises first and second curved tangs formed coplanar with the flat base.

23. The cage-nut assembly of claim 22, wherein the nut includes a protruding tubular portion which extends through the bolt-receiving aperture.

24. The cage-nut assembly of claim 22 or claim 23, wherein the flat base is supported by standoff legs, and the legs include bendable retainer tabs configured to hold the nut in position, said bendable retainer tabs being bendable to allow movement of the nut away from the flat base in a perpendicular direction with respect to the flat base.

25. The cage-nut assembly of claim 24, wherein said standoff legs include small projections to facilitate projection welding.

5

10

15

20

25

30

35

40

45

50

55

Fig. 1

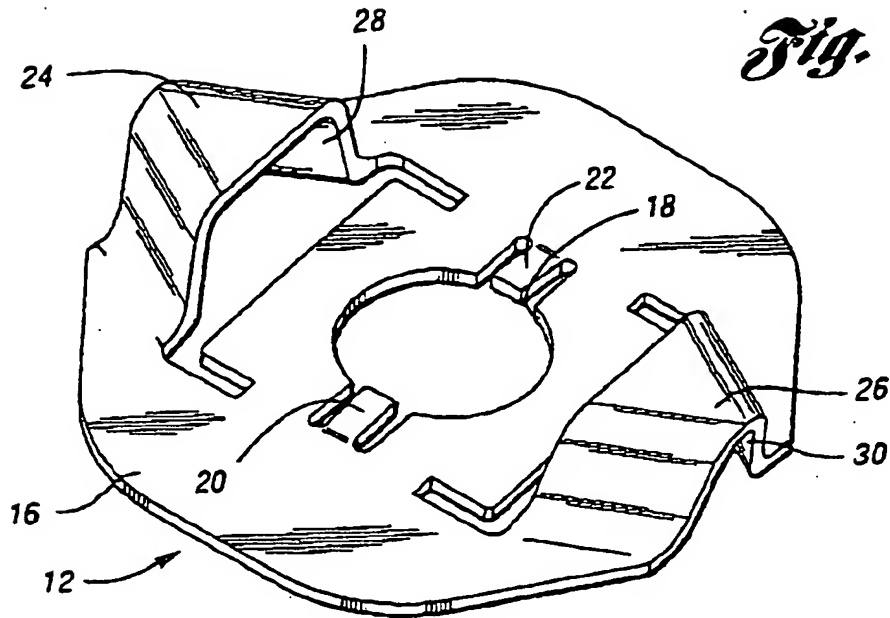


Fig. 3

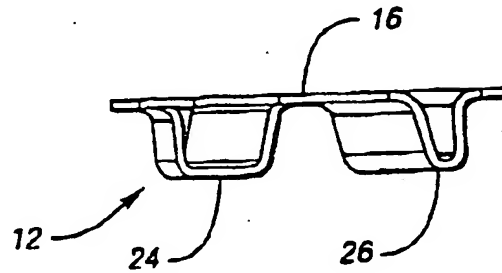


Fig. 2

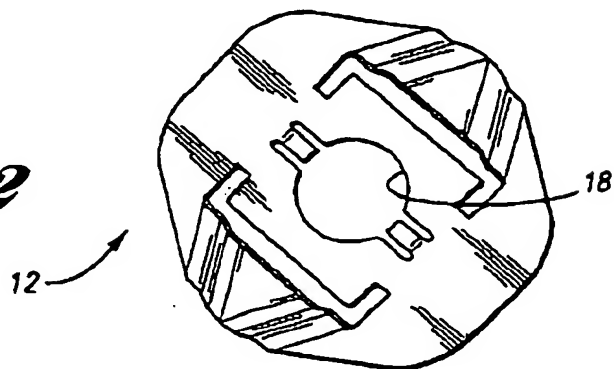
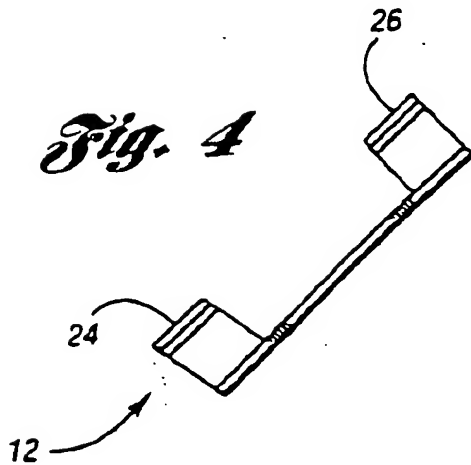


Fig. 4



BEST AVAILABLE COPY

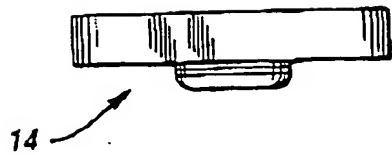


Fig. 7

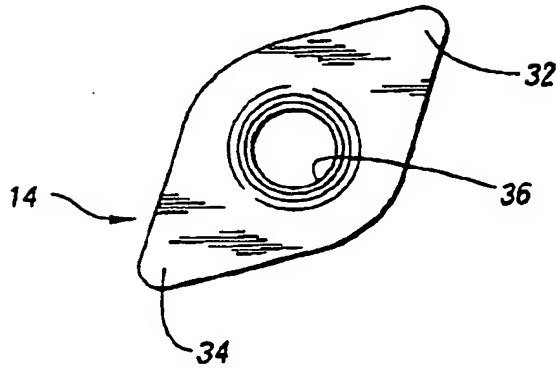


Fig. 5

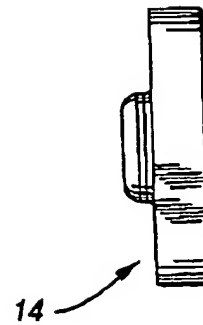


Fig. 6

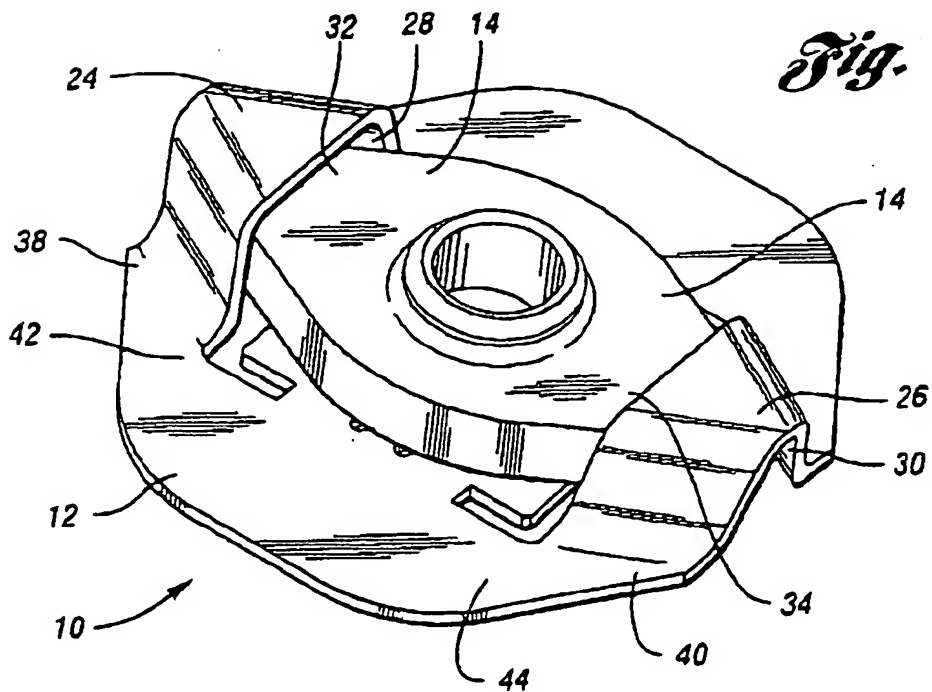


Fig. 8

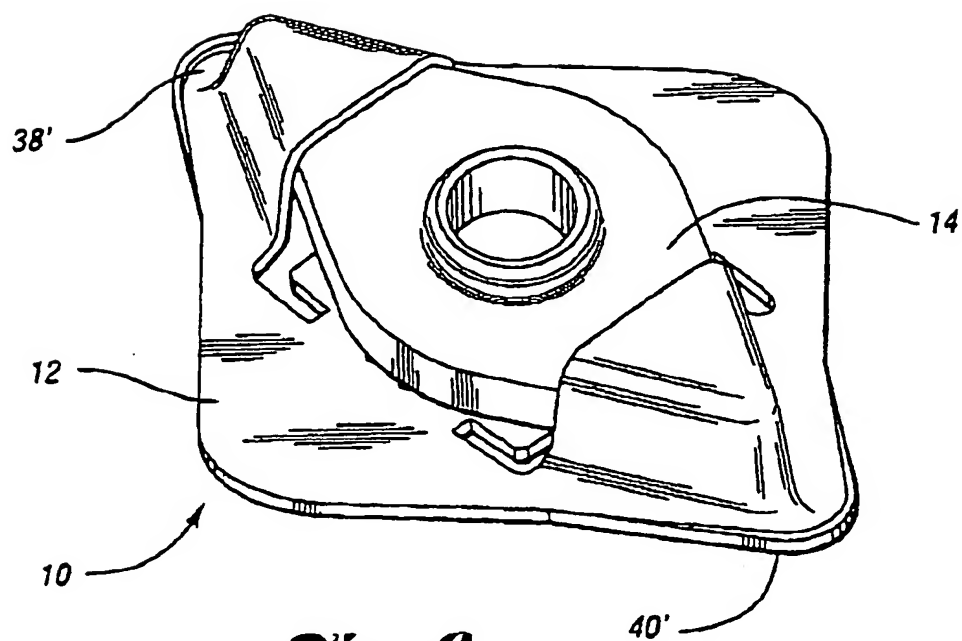


Fig. 9

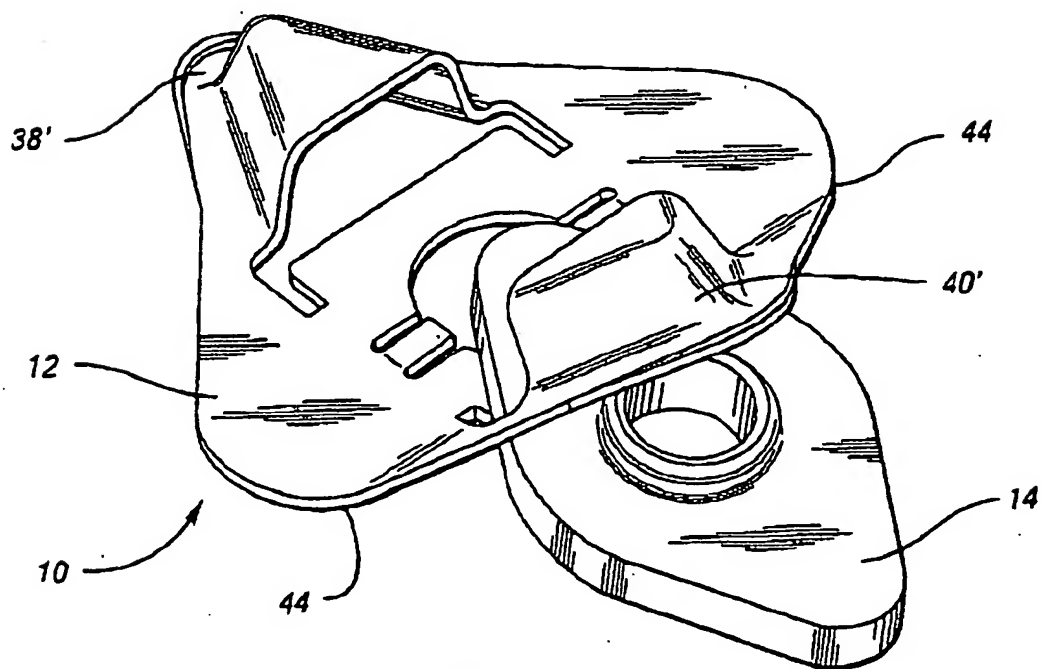


Fig. 10

Fig. 11

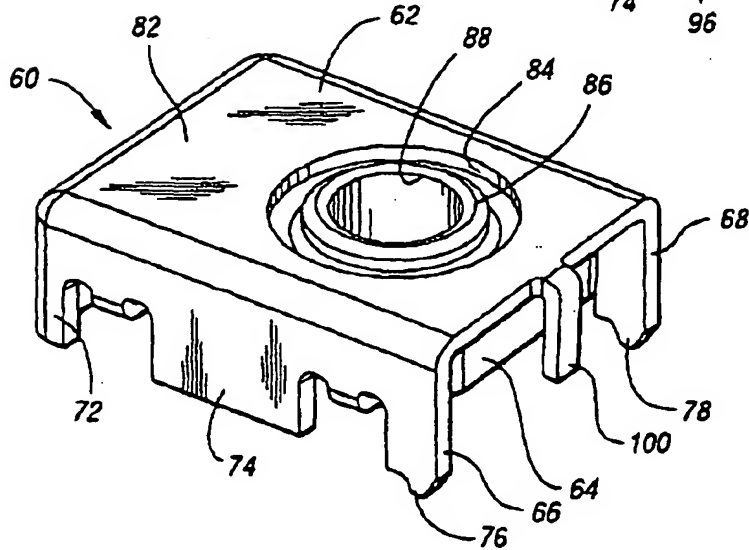
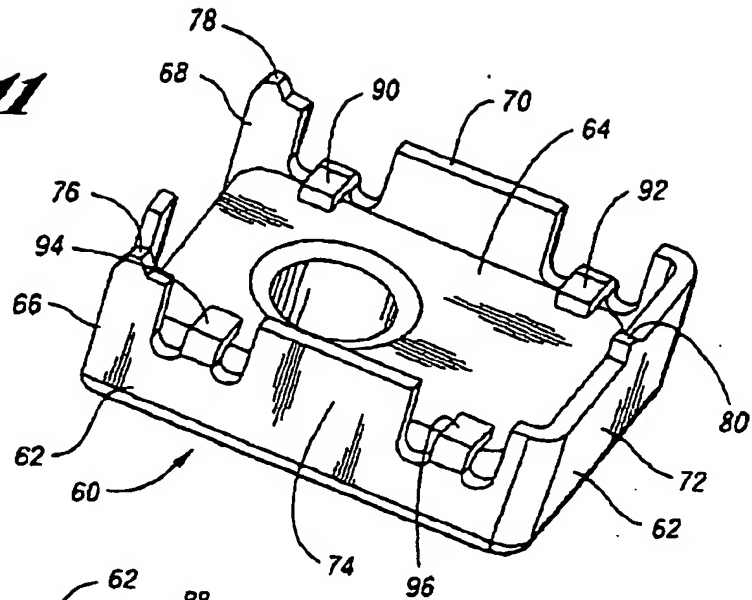
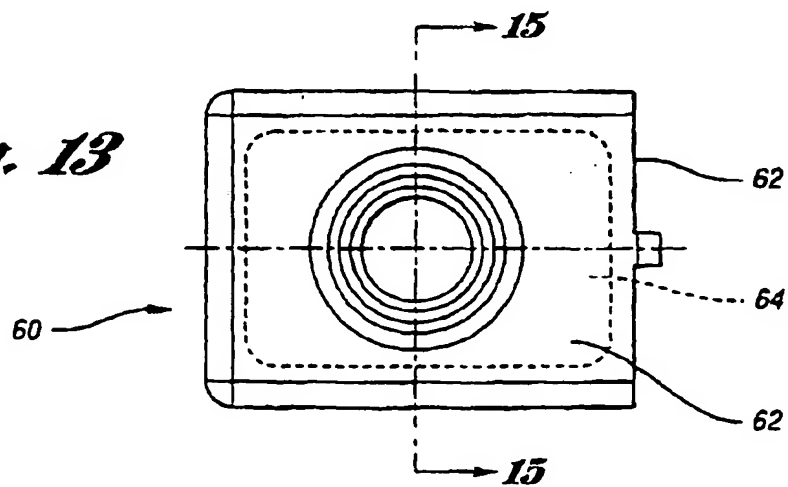


Fig. 12

Fig. 13



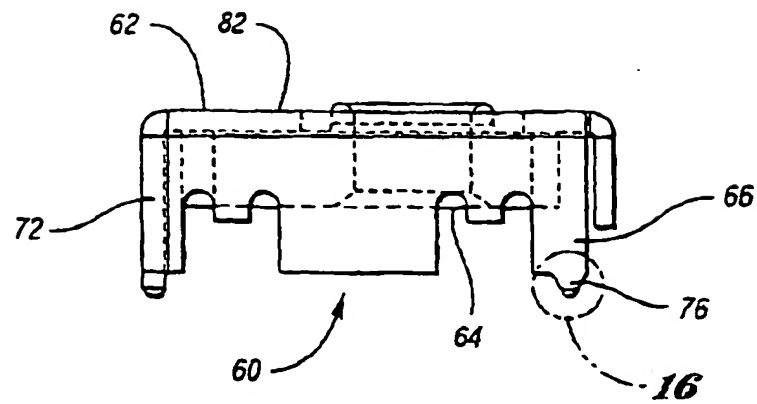


Fig. 14

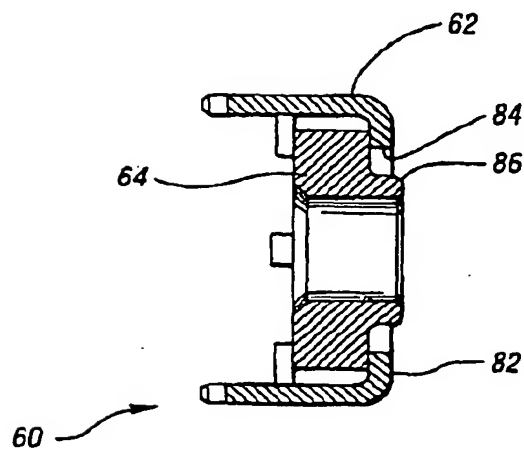


Fig. 15

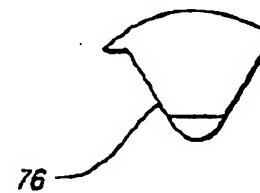


Fig. 16

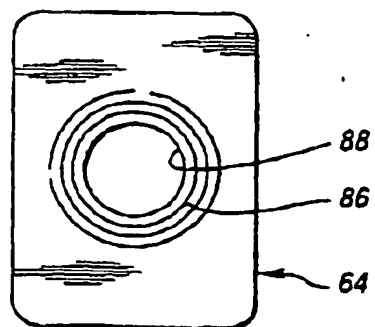


Fig. 17

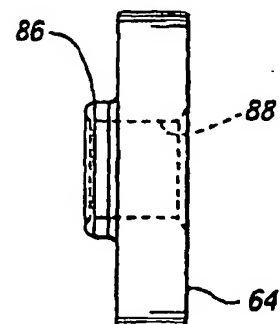


Fig. 18

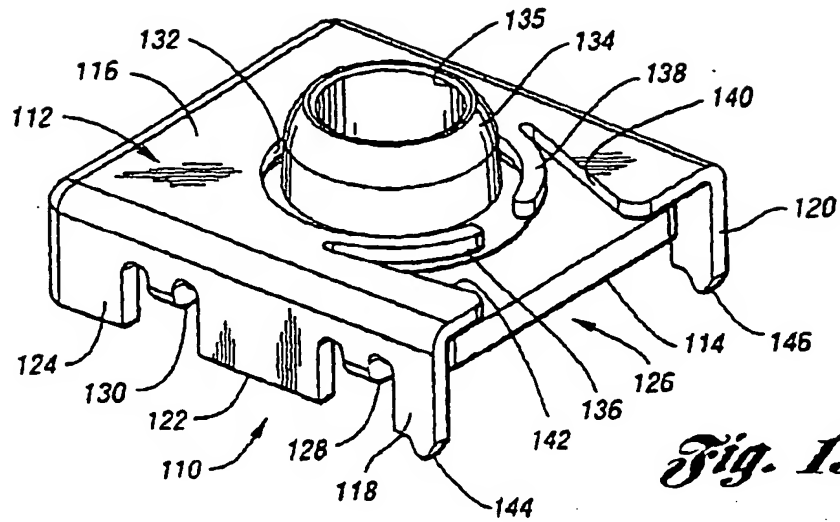


Fig. 19

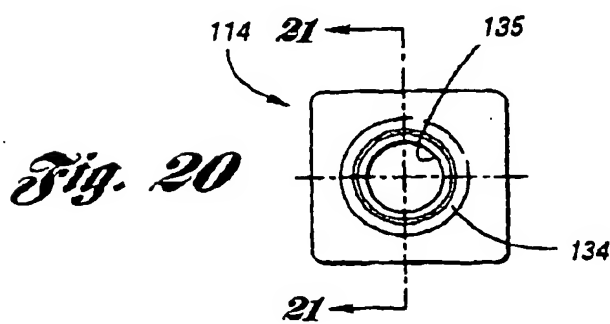


Fig. 20

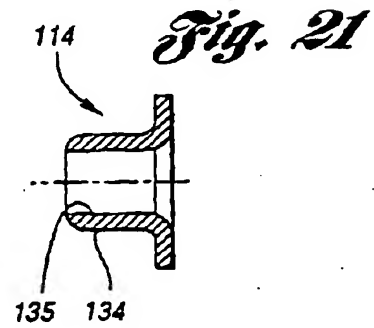


Fig. 21

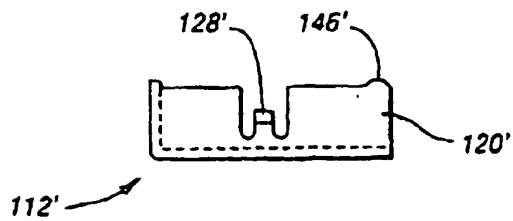


Fig. 23

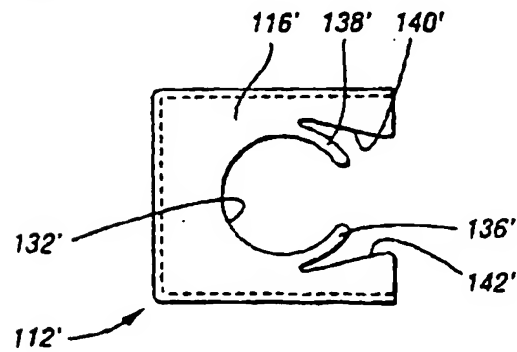


Fig. 22

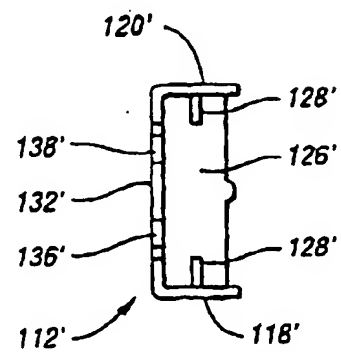


Fig. 24



European Patent
Office

EUROPEAN SEARCH REPORT

Application Number
EP 01 30 0222

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (InLCI.7)
X	US 4 875 816 A (PETERSON FRANCIS C) 24 October 1989 (1989-10-24)	1,7-10, 20,21	F16B37/04
Y	* column 3, line 1 - line 12; figures 1,2 *	13	
X	FR 2 756 601 A (SIMMONDS SA) 5 June 1998 (1998-06-05)	1,3,4,7, 8	
Y	* page 3, line 33 - page 4, line 6; figures 1,5 *	2,5	
Y	US 5 096 350 A (PETERSON FRANCIS C) 17 March 1992 (1992-03-17)	2,5	
A	* column 2, line 1 - line 9 * * column 3, line 65 - column 4, line 18; figures 1,4 *	1,7-9	
Y	EP 0 636 800 A (OPEL ADAM AG) 1 February 1995 (1995-02-01)	13	
A	* column 3, line 57 - column 4, line 30; figures *	1,3,7,9, 11,12	
A	FR 1 564 898 A (RAPID S.A.) 25 April 1969 (1969-04-25) * page 2, column 2, line 1 - line 10; figure 1 *	1,3,4, 6-8	TECHNICAL FIELDS SEARCHED (InLCI.7) F16B B62D
The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 28 March 2001	Examiner Axelsson, T
CATEGORY OF CITED DOCUMENTS X: particularly relevant if taken alone Y: particularly relevant if combined with another document of the same category A: technological background O: non-written disclosure P: intermediate document		1: theory or principle underlying the invention E: earlier patent document, but published on, or after the filing date D: document cited in the application L: document cited for other reasons &: member of the same patent family, corresponding document	

EP 01 30 0222 (2001)

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 01 30 0222

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

28-03-2001

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
US 4875816	A	24-10-1989	NONE	
FR 2756601	A	05-06-1998	NONE	
US 5096350	A	17-03-1992	NONE	
EP 0636800	A	01-02-1995	DE 4321922 A	12-01-1995
FR 1564898	A	25-04-1969	NONE	

EPO FORM P0412

For more details about this annex : see Official Journal of the European Patent Office, No. 12/82

**This Page is Inserted by IFW Indexing and Scanning
Operations and is not part of the Official Record**

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images include but are not limited to the items checked:

- ☐ BLACK BORDERS
- ☐ IMAGE CUT OFF AT TOP, BOTTOM OR SIDES
- ☐ FADED TEXT OR DRAWING
- ☒ BLURRED OR ILLEGIBLE TEXT OR DRAWING
- ☐ SKEWED/SLANTED IMAGES
- ☐ COLOR OR BLACK AND WHITE PHOTOGRAPHS
- ☐ GRAY SCALE DOCUMENTS
- ☐ LINES OR MARKS ON ORIGINAL DOCUMENT
- ☐ REFERENCE(S) OR EXHIBIT(S) SUBMITTED ARE POOR QUALITY
- ☐ OTHER: _____

IMAGES ARE BEST AVAILABLE COPY.

As rescanning these documents will not correct the image problems checked, please do not report these problems to the IFW Image Problem Mailbox.